

SPLIT

PRELIMINARY ISSUE

Work Order ID 61885-



Page 1

Wednesday, September 08, 2010 3:28:31 PM

Item ID:	D4181-1	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Pod Frame Platform					
Start Date:	9/8/2010	Start Qty:	3.00			
Required Date:	9/13/2010	Req'd Qty:	3.00			
Reference:						

Approvals:	Process Plan:		Date:	10-9-05	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4181	PA1								
100		0.00							
Waterjet									
FLOW CNC Waterjet									
	Memo	0.00							
	1-Cut as per Dwg								
	Dwg Rev:								
	Prog Rev:								
	2-Deburr if necessary								
110		0.00							
QC									
Quality Control									
	Memo	0.00							

MKT NOT PULLED

10-9-13

3

10-9-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 61885

Wednesday, September 08, 2010 3:28:31 PM



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Item ID: D4181-1  
Revision ID: PRELIM  
Item Name: Pod Frame Platform

Accept



Setup Start



Stop



Start Date: 9/8/2010 Start Qty: 3.00  
Required Date: 9/13/2010 Req'd Qty: 3.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
124		0.00							
Small Fab	Memo	0.00							
Small Fab	1- C'sink holes as per dwg								
126	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

inspected to spec

Done only

8/10/09/13

(x3)

8/10/09/21 (3)

inspected to spec

Done only

8/10/09/21 (x3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61885**

Wednesday, September 08, 2010 3:28:31 PM



Page 3

Item ID: D4181-1  
Revision ID: PRELIM  
Item Name: Pod Frame Platform

Accept



Setup Start



Stop



Start Date: 9/8/2010 Start Qty: 3.00  
Required Date: 9/13/2010 Req'd Qty: 3.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



HandFinish  
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

=&gt; MU 10/09/21

X3

✓

Memo

0.00

140



Powdercoat  
Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

=&gt; MU 10/09/22

X3

✓

Memo

0.00

Start Time: 6:30 AM  
Oven Temperature: 320°F  
Finish Time: 7:00 AM

150



QC  
Quality Control

QC3- Inspect Part Finish

0.00

FT 10-09-22 (X3)

Memo

0.00



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 61885

Wednesday, September 08, 2010 3:28:31 PM



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Item ID: D4181-1 Accept

Revision ID: PRELIM

Item Name: Pod Frame Platform

Start Date: 9/8/2010 Start Qty: 3.00

Required Date: 9/13/2010 Req'd Qty: 3.00

Reference:



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location: CA

0.00



Packaging

Memo

Jan 0.00

Packaging

ST 10 09 23 (S)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/29 AF

U 10-09-23

POSITIVE RECALL

EFFECTIVE 0.9.09 AUTH U

RELEASED J DATE 10.09.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, September 08, 2010 3:28:36 PM

Page 1

Work Order ID: 61885



Parent Item: D4181-1



Parent Item Name: Pod Frame Platform


Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.08 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.250  6061T6 SHEET .250		Purchased	No			100	sf	0.0000	0.653	2.062105	3.	10-9-13	

6061 T6S 1250 x 6.000

M115212

M115212

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

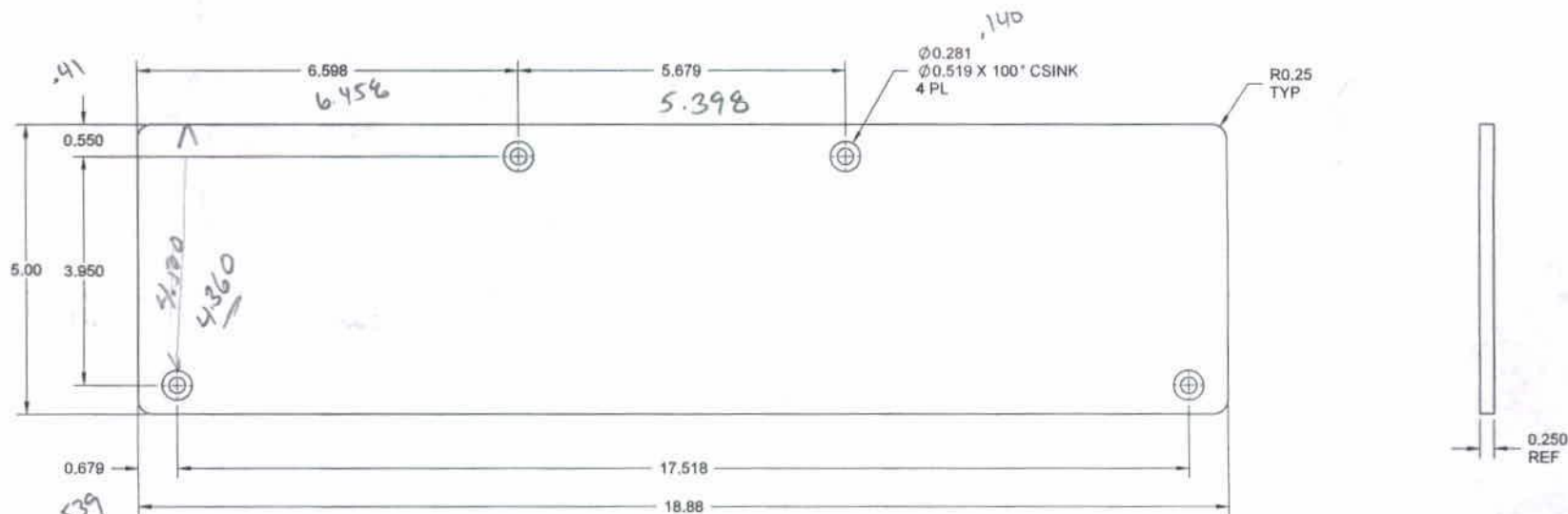
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Route/Bom/Bxf  
 ✓  
 DOWE



**D4181-1 POD FRAME PLATFORM**

**PRELIMINARY ISSUE**  
 10.09.08

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED  
 SUBJECT TO APPROVAL  
 WEIGHT

NO. 41885  
 10-9-09

- NOTES:
- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.250 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.250
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDING" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 2.29 lbs

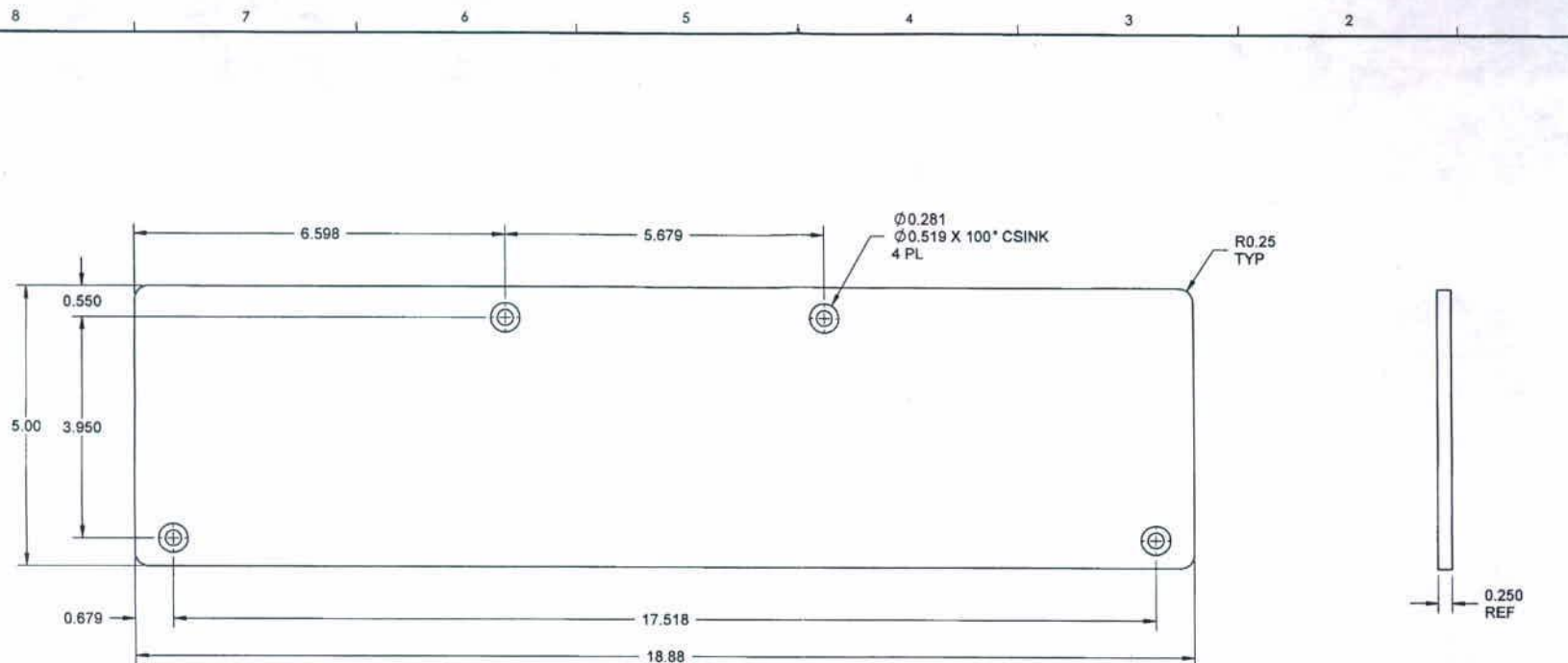
PA1	NEW ISSUE	MB	10.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.03		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4181</b>	REV. PA1 SHEET 1 OF 1
TITLE <b>POD FRAME PLATFORM</b>	SCALE NTS
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**D4181-1 POD FRAME PLATFORM**

**NOTES:**

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.250 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S 250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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REV.	DESCRIPTION	MB	DATE
A	NEW ISSUE		10.09.03
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.03		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
**D4181**

REV. A  
SHEET 1 OF 1

TITLE  
**POD FRAME PLATFORM**

SCALE  
NTS

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*61885*  
**RELEASED**  
2010-09-29  
*MP*